



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT200078
Job Sheet 189421



Part No: RBT200078

Job Qty: 4 pcs *5*

DAS
21
9-89

Part Name: Trunnion Bearing Removal & Install Work Aid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/24/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT200078 Rev. 2A IPP Rev. A 18.07.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	2/28/19	2/28/19	0.00	0.29	External Load - 1		<i>AP 2019/03/05</i>
							External Load - 2		
							External Load - 3		
							Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	2/28/19	2/28/19	0.00	0.00	QC 5 - 10		<i>DAS</i> <i>MAR 07 2019</i> <i>68</i> <i>9-89</i>
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 2-1 - Receive - B4B	4 pcs	2/28/19	2/28/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		



Container No: S159388



Part: RBT200078

Job No: 189421

Serial No/Batch: S159388

Revision: 2A

Inspector:

Exp Date:

Instructions:

Date: 03/05/19

Plex 3/5/19 4:00 PM Dart.Hadley.Shannon

				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	MCC
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
140	QC 21 - FG	4 pcs	2/28/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
Part Op 100 - (Small Fab) Assemble as per DWG. Descriptions: 110 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) Bag and tag 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBT200078-1	Trunnion Bolt (Hex Head Cap Screw)	4 pcs (1 ea)	100-Small Fab - 1		
RBT200078-2	Trunnion Body	4 pcs (1 ea)	100-Small Fab - 1		
RBT200078-3	Trunnion Spreader	4 pcs (1 ea)	100-Small Fab - 1		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Small Fab - 1	RBT200078-1	4	7	0	
	RBT200078-2	4	5	0	
	RBT200078-3	4	5	0	
Part Specifications					
Specifications could not be found.					

Plex 3/5/19 4:00 PM Dart.Hadley.Shannon



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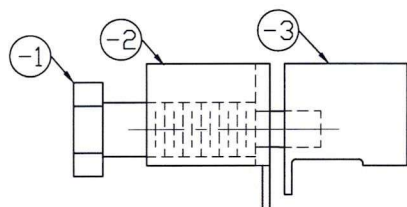
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							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
110	QC 5	4 pcs	2/28/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
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							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	

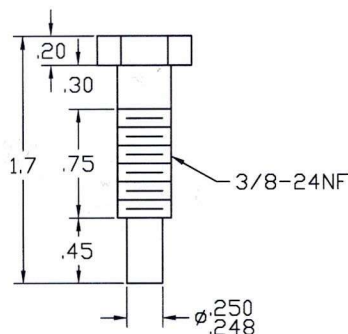
Plex 1/24/19 8:43 AM Dart.lajeunesse.marie

				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
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Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
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RBT200078-2	Trunnion Body	5 4 pcs (1 ea)	100-Small Fab - 1	5149592	
RBT200078-3	Trunnion Spreader	5 4 pcs (1 ea)	100-Small Fab - 1	5149823	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Small Fab - 1	RBT200078-1	4	3	0	
	RBT200078-2	4	1	0	
	RBT200078-3	4	1	0	
Part Specifications					
Specifications could not be found.					

Plex 1/24/19 8:43 AM Dart.lajeunesse.marie



ASSEMBLY VIEW

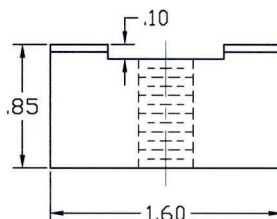
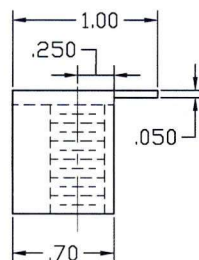
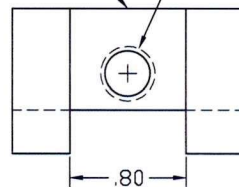


(1)

BOLT

3/16 TEXT "RBT200078"

DRILL & TAP
3/8-24NF THRU



(2)

BODY

HEAT TREAT 35-40 Rc

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

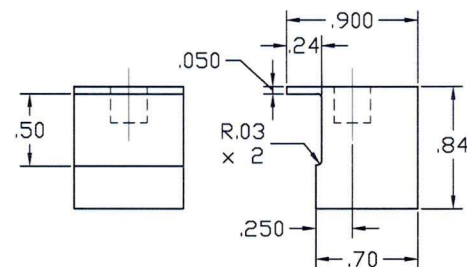
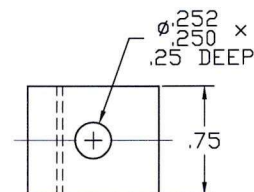
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 189421

ML5
19-01-24



(3)

SPREADER

HEAT TREAT 35-40 Rc

ASSY QTY	QTY	B/D	PART #	UNIT QTY	DESCRIPTION	MAT.	B/D INFORMATION OR SPECIFICATIONS
		W/D	-1	1	HEX HEAD CAP SCREW	BLACK	3/8-24 x 1-3/4
			-2	1	BODY	4140	1 x 1-1/4 x 1-3/4
			-3	1	SPREADER	4140	1 x 1-1/4 x 7/8
ASSY							

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CHANGED BOLT PIN FROM #.247, AND -3 HOLE FROM #.250; ALSO CHANGED P/N FROM T200078	8/16/06	WP
2	ADDED NEW TITLE BLOCK, BOM, & REVISIONS TABLE, AND ASSEMBLY VIEW. ALSO CHANGED MATERIAL DESCRIPTION FROM 1 in. WIDE.	3/6/08	WP
2A	CH'D BOM LENGTH FROM 13/16 TO 7/8 -3 PER R.W.	12/17/10	RJC

RED BARN MACHINE	
TITLE TRUNNION BEARING REMOVAL AND INSTALLATION WORK AID	
DWG NO. RBT200078	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-15-01
SHEET 1 of 1	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					